

Date: Wednesday, 1/11/2006 4:30:56 PM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: BRACKET
Job Number	: 25485		
Estimate Number	: 10379		
P.O. Number	: <i>N/A</i>	Part Number	: D3195041
This Issue	: 1/11/2006	S.O. No.	: <i>N/A</i>
Prsht Rev.	: NC	Drawing Number	: D3195 REV A
First Issue	: <i>N/A</i>	Project Number	: N/A
Previous Run	: 25241	Drawing Revision	: A
	Type : MACHINED PARTS	Material	: <i>N/A</i>
Written By	: <i>SEE COMMENT Below</i>	Due Date	: 1/30/2006
Checked & Approved By	: <i>SEE COMMENT Below</i>	Qty:	20 Um: Each
Comment	: Est Rev:A New Issue 05-11-08 JLM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M6061T6B0750X02000	6061-T6 Bar .75" x 2.0"
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Comment: Qty.: 0.3150 f(s)/Unit Total : 6.3000 f(s)
 Material: 6061-T6/T651 (QQ-A-200/8) or (QQ-A-225/8) or (QQ-A-250/11)
 (M6061T6B0.750x02.000)
 Identify for D3195-1
 Batch: ~~6061T6~~ *M18571*

2.0	BAND SAW	BAND SAW
-----	----------	----------



Comment: BAND SAW
 Cut blanks: (0.75" x 2.00") x 3.60" long

JF. 06/01/30 21

3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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Comment: HAAS CNC VERTICAL MACHINING #1

Machine D3195-1 as per Folio FA334 and Dwg D3195
 Identify as D3195-1

Deburr

JF./J.L 06.01.31 20 P.T.O

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

JF./J.L 06.01.31 20

5.0	QC8	SECOND CHECK
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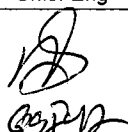
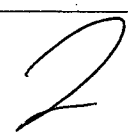
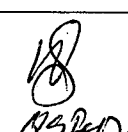
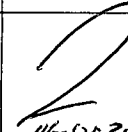
Comment: SECOND CHECK

36 06.02.13 20

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☐ No ☒ DQA: ☒ Date: 06/02/16
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
06/01/30	3	Pant too thin. was installed incorrectly.		Pant installed properly Scrap: replace	J.F. 06/01/30	 06-01-31		 06-01-31

NOTE: Date & initial all entries

Date: Wednesday, 1/11/2006 4:30:56 PM
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Process Sheet

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Drawing Name: BRACKET

Job Number: 25485

Part Number: D3195041

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

ml

06 02 13

20

7.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

a.m 06-02-13

20

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

FL 060213 20

9.0

D31955

Pad



Comment: Qty.: 1.0000 Each(s)/Unit Total : 20.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D3195-5

PAD

D23489

10.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Bond D3195-5 into D3195-1 as per Dwg D3195Pick:

Qty Description Batch

A/R Contact Cement *M 10008*

Identify as D3195-041

SB 06/02/14 (20)

11.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

06-02-15 20

12.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

ST134

06/2/15 (20)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 1/11/2006 4:30:57 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BRACKET

Job Number: 25485

Part Number: D3195041

Job Number:



Seq. #:

Machine Or Operation:

Description :

13.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

545 06/02/16

(20)

SP 06/02/16

Job Completion



Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

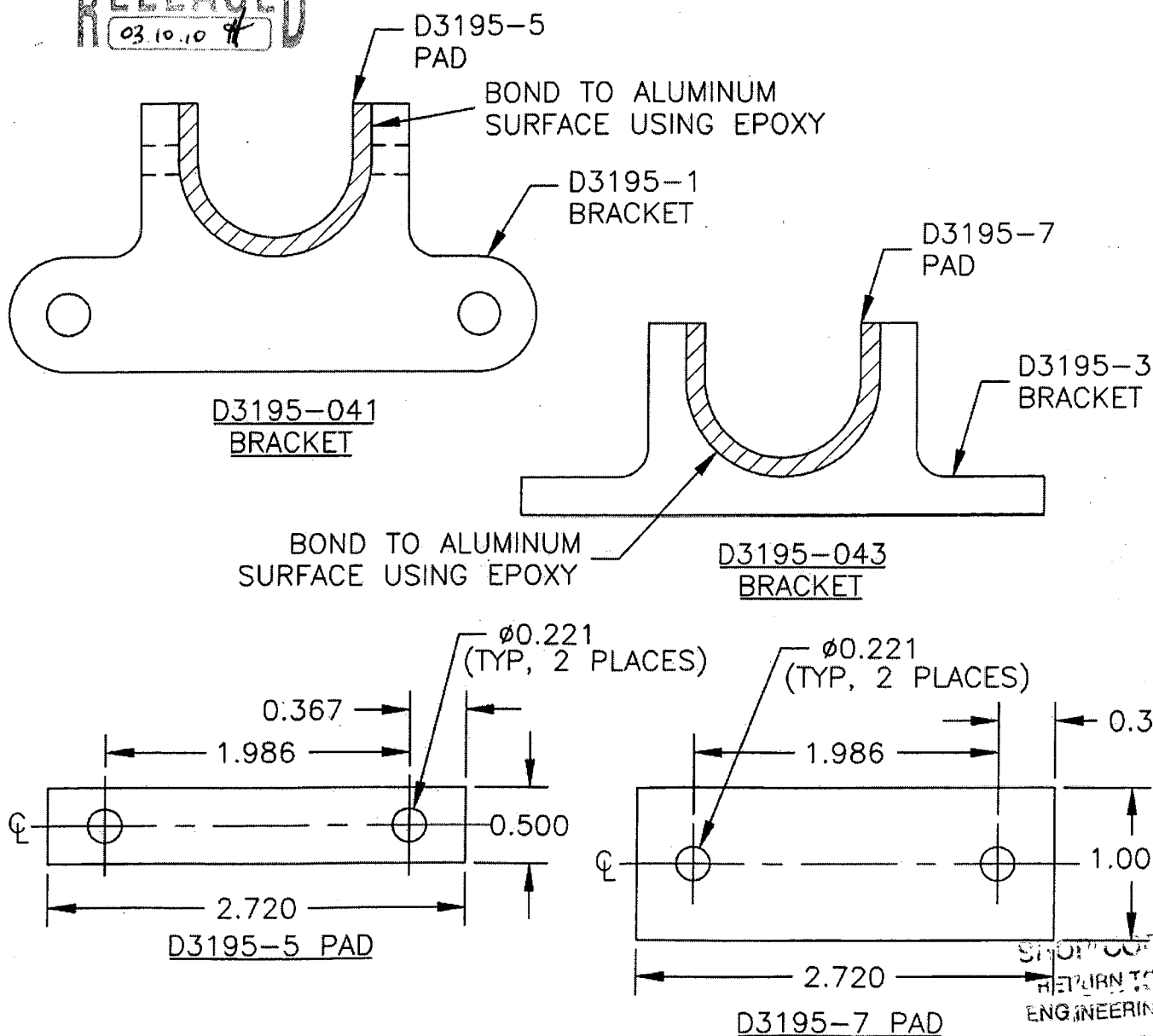
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN	CP	DRAWN BY	CP	DART AEROSPACE LTD
				HAWKESBURY, ONTARIO, CANADA
CHECKED	#	APPROVED	#	DRAWING NO. D3195
				REV. A
DATE	03.06.23	TITLE	BRACKET	SHEET 1 OF 3
				SCALE 1:1
A	03.06.23	NEW ISSUE		

RELEASED
03.10.10



D3195-5 & D3195-7 PAD

- 1) MATERIAL: 60 DUROMETER NEOPRENE 1/8" THICK
(POSSIBLE SUPPLIERS, ACCURATE RUBBER)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 3) ALL DIMENSIONS ARE IN INCHES

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SUBJECT TO AMENDMENT
WITHOUT NOTICE

WORK ORDER
NO. 25485

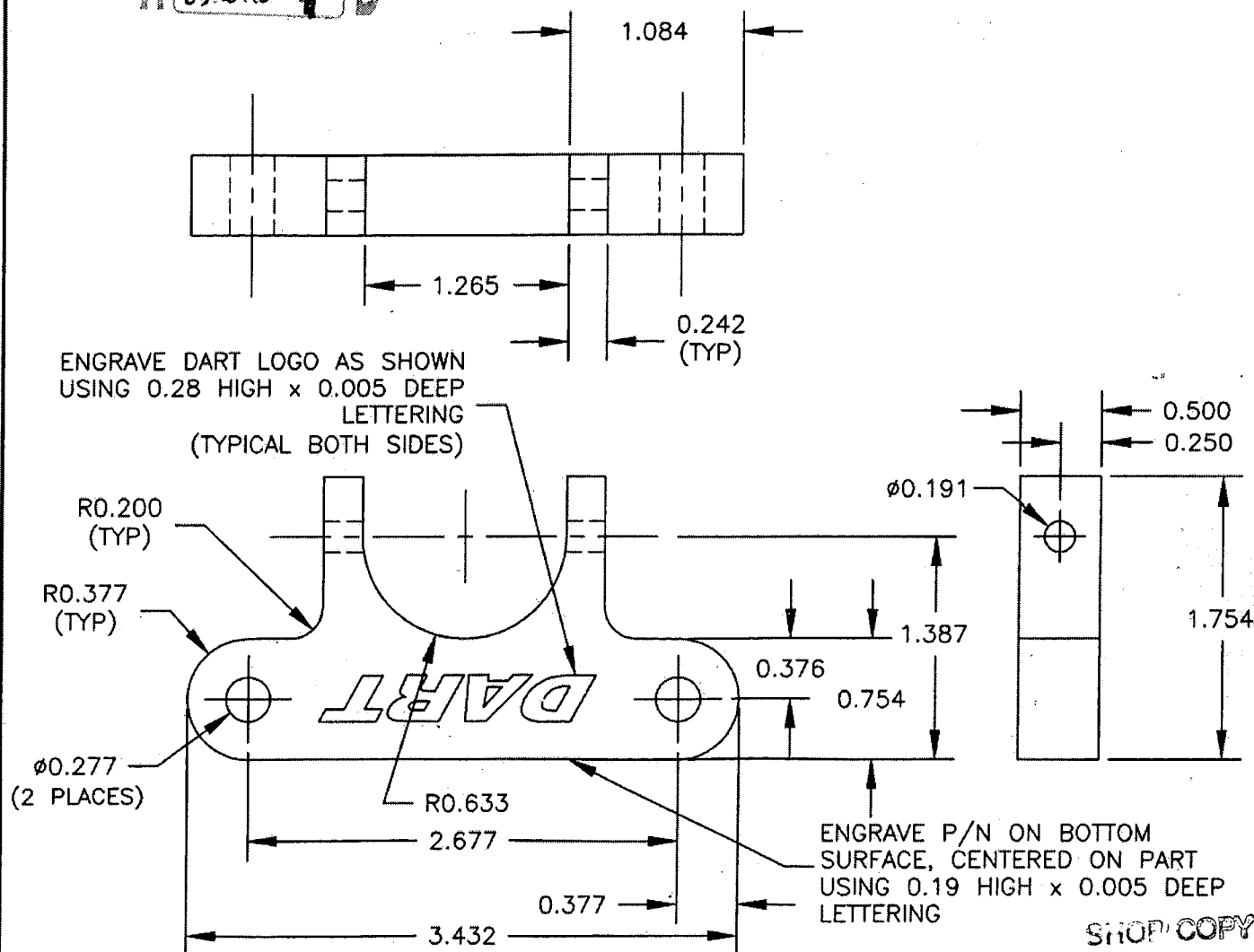
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CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D3195	REV. A SHEET 2 OF 3
DATE 03.06.23		TITLE BRACKET	SCALE 1:1

RELEASED
03.10.10



D3195-1 BRACKET

- 1) MATERIAL: 6061-T6/T651 (QQ-A-250/11 OR QQ-A-200/8 OR QQ-A-225/8) (REF. DART SPEC M6061T6S OR M6061T6B) SUBJECT TO AMENDMENT WITH NOTICE
- 2) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 3) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER DART QSI 005 4.3
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES

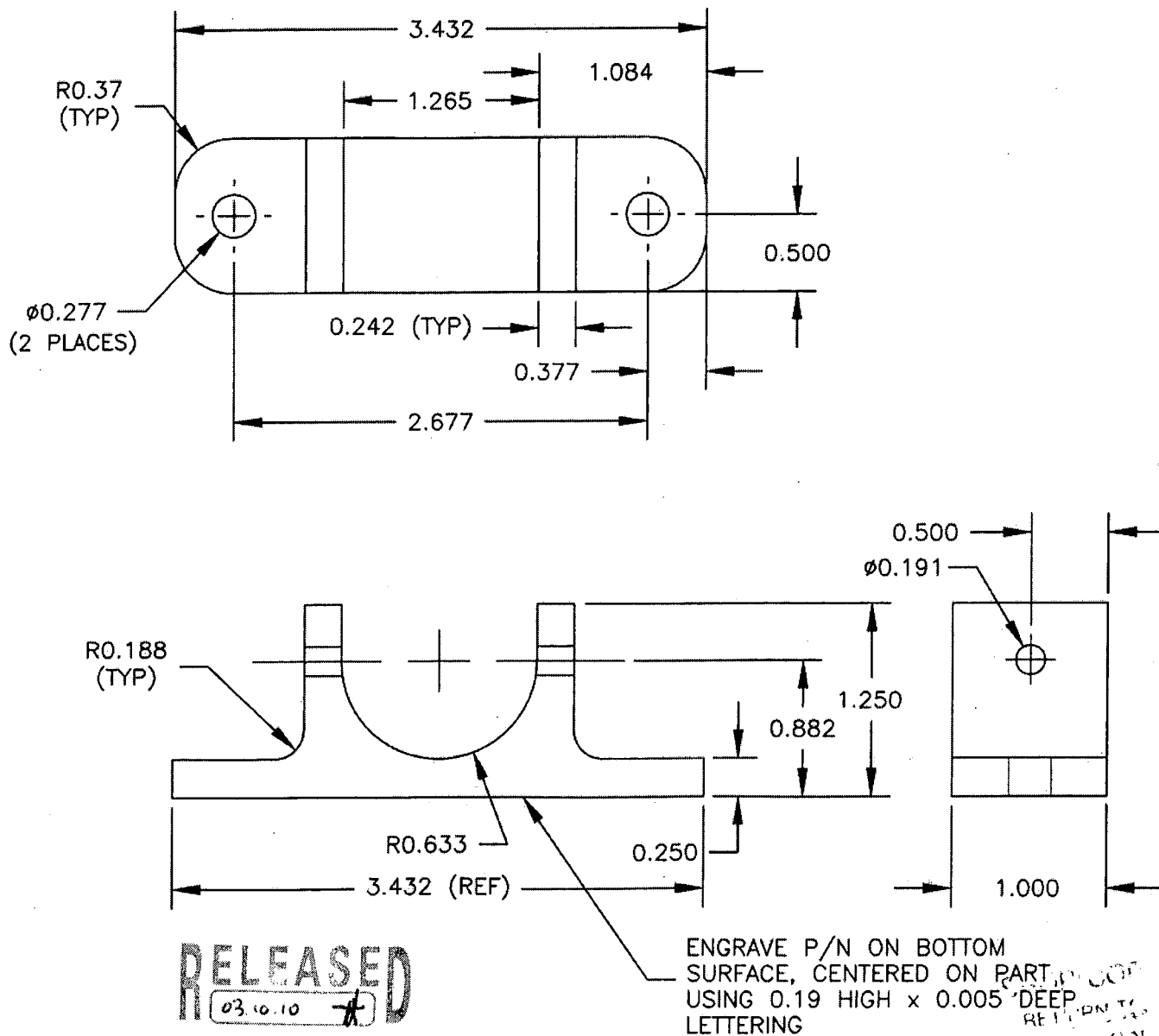
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CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3195	REV. A SHEET 3 OF 3
DATE 03.06.23		TITLE BRACKET	SCALE 1:1



D3195-3 BRACKET

- 1) MATERIAL: 6061-T6/T651 (QQ-A-250/11 OR QQ-A-200/8 OR QQ-A-225/8) (REF. DART SPEC M6061T6S OR M6061T6B)
- 2) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 3) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER DART QSI 005 4.3
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES

WORK ORDER
NO. 25485

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